

# Work Order ID 86798

July-06-12 2:53:49 PM

**\*86798\***

Page 1

Item ID: D2989-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Lid Assembly  
 Start Date: 7/06/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12079 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2989	Rev D

100 0.00  
**\*100\*** Large Fab  
 Large Fab Memo 0.00  
 Large Fab  
 1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989  
 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig  
 \*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*  
 3- remove from jig and weld lable plate as per dwg D2989  
 A/R ER316 S.S. Rod Batch: 4118161  
 \*\*\* PLEASE NOTE\*\*\*\*  
 IF MAKING -043A :  
 ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER  
 DSI9473

*12-10-05*

110 0.00  
**\*110\*** QC9- Inspect visual per QSI004- Fusion Welds  
 QC Memo 0.00  
 Quality Control

**DAS**  
**24**  
**9-89**  
12-10-04

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
*120*									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
*125*									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
16  
9-8 17/10/09

1 NB 12-109

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes prior to powder coating  2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989  1ST COAT: START TIME: <u>1:20</u> OVEN TEMPERATURE: <u>400 F</u> FINISH TIME: <u>1:50</u> ***** 2nd coat if necessary *****  2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00  0.00				<u>1X</u>	<u>0</u>		<u>M-L</u> <u>12/10/09</u>
131 <b>*131*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>10500</u>  Memo Mask lid prior to spray paint black and wing walk as per dwg A/R Spray paint black batch: <u>114443</u>	0.00  0.00				<u>1</u>	<u>0</u>		<u>BL 12-10-10</u>

*M122878*

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# Picklist Print

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Page 1

Work Order ID: 86798  
Parent Item: D2989-041  
Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM  
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC  
IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10.09.14 added pressure  
wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	2				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
D2506 Label Plate		Manufactured	No			100	Each	12.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				79197		1							
				82705		11							
D2512-7 Rib		Manufactured	No			100	Each	8.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				53444		0							
				77522		4							
				81048		4							

B86848 → 1x SJ 12-10-03

B86847 → 1x

B82705 → 1x SJ 12-10-03

B86951 → 1x SJ 12-10-03

W/O:		WORK ORDER CHANGES					
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Parent Item: D2989-041  
Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 59.0000  
Mounting Bracket

Location	Loc Qty	Loc Code
WA	37	
82506	2	
83230	3	
85436	8	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

<sup>2</sup> B86961 → 1x SJ 12-10-03  
B87706 → 1x

D2989-13 Manufactured No 100 Each 4.0000  
Rib

Location	Loc Qty	Loc Code
WA	4	
84604	4	

<sup>2</sup> B87721 → 2x SJ 12-10-03

D2989-19 Manufactured No 100 Each 10.0000  
Rib

Location	Loc Qty	Loc Code
WA	10	
77519	4	
84603	6	

<sup>2</sup> B87650 → 2x SJ 12-10-03

D3832-3 Manufactured No 100 Each 1.0000  
Mesh (Lid)

Location	Loc Qty	Loc Code
WA035	1	
77520	1	

<sup>1</sup> B87389 SJ 12-10-03

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D2989-041  
Parent Item Name: Basket Lid Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No 100 Each 13.0000  
Mesh (Lid End)

<sup>2</sup> B87412 SY 12.10.05

Location	Loc Qty	Loc Code
WA	4	
81142	4	
WA035	9	
67460	9	

D3836-041 Manufactured No 100 Each 4.0000  
Rib Assembly (Basket Lid, LH)

<sup>1</sup> B89445 → 1x SY 12.10.03

Location	Loc Qty	Loc Code
WA	4	
77515	4	

D3836-042 Manufactured No 100 Each 4.0000  
Rib Assembly (Basket Lid, RH)

<sup>1</sup> B89448 → 1x SY 12.10.03

Location	Loc Qty	Loc Code
WA005	4	
77514	4	

D3852-041 Manufactured No 100 Each 6.0000  
Rib Assembly

<sup>1</sup> B87906 → 1x SY 12.10.03

Location	Loc Qty	Loc Code
WA005	6	
77512	2	
86042	2	
86154	2	

D3852-042 Manufactured No 100 Each 5.0000  
Rib Assembly

<sup>1</sup> B87905 → 1x SY 12.10.03

Location	Loc Qty	Loc Code
WA	1	
77513	1	
WA005	4	
66089	1	
77513	1	
86043	2	

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 86798  
12-07-9

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
8) WELD PER DART QSI 004



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/16

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2989</b> TITLE <b>BASKET LID ASSEMBLY</b> REV. D SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED BY "X" EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

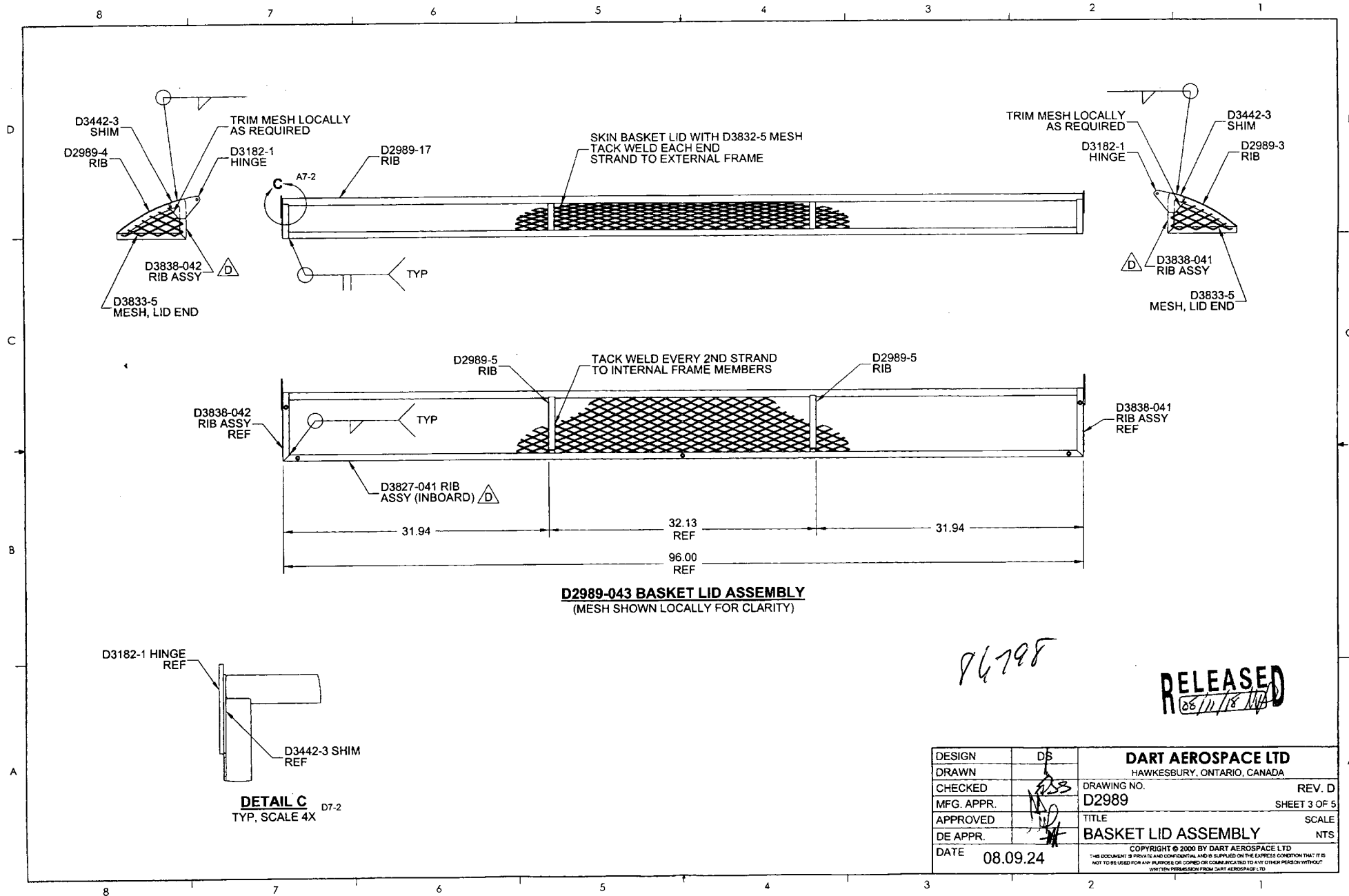
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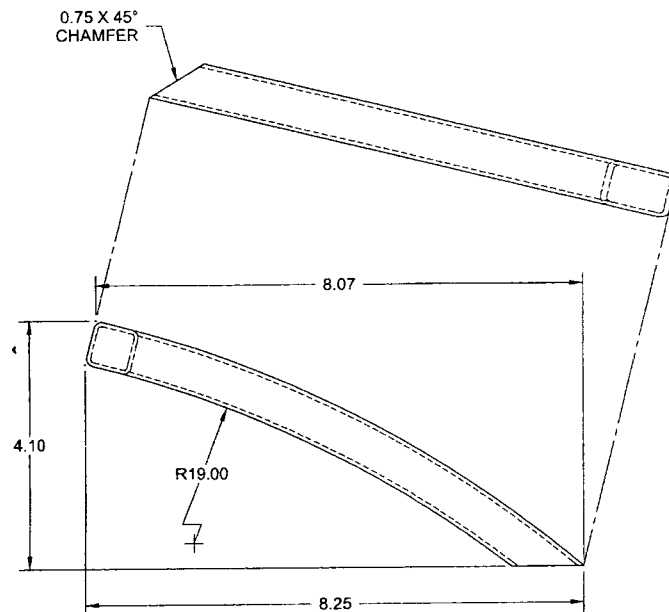
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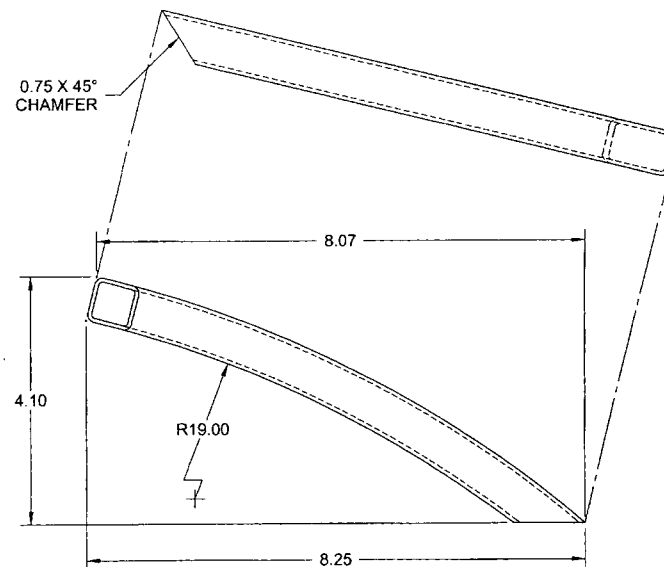
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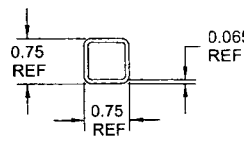
**D2989-3 RIB**



**D2989-4 RIB**




86798

**RELEASED**  
08/11/18/10



**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

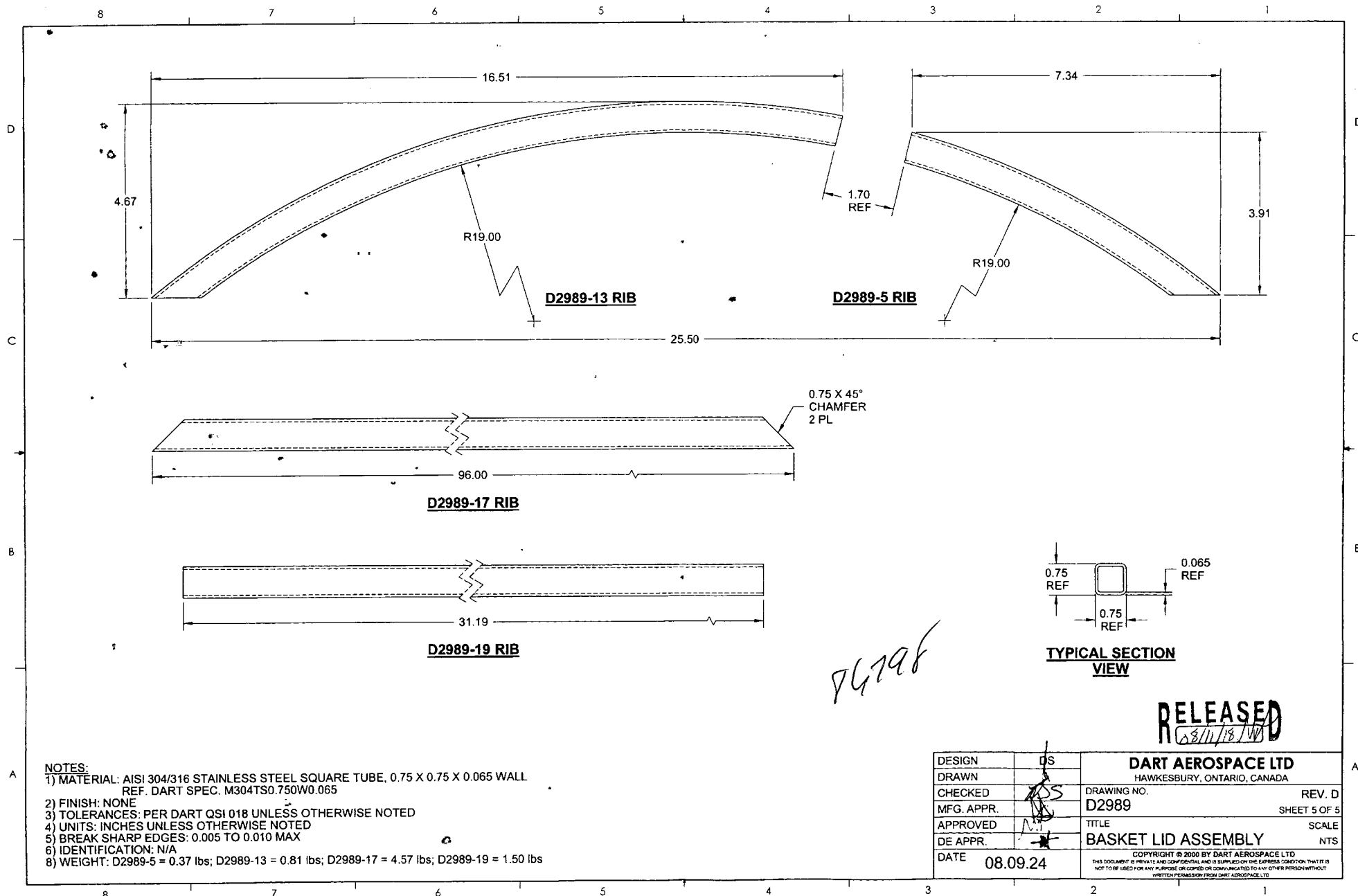
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DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.	DS	SHEET 5 OF 5	
APPROVED	DS	TITLE <b>BASKET LID ASSEMBLY</b>	SCALE NTS
DE APPR.	DS	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	08.09.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries